

Work Order ID 60308

Thursday, July 01, 2010 1:11:51 PM



Page 1

Item ID: D2261

Accept



Setup Start



Revision ID:

Stop



Item Name: Mirror Arm - Long S76

Start Date: 7/1/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

10-7-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2261	Rev A1

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch tube 304/316 with 2B finish ☐ Form as per dwg D2261 ☐ Deburr

= 7 M. L 10/07/08

(2X)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.060712

(12)

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:15

☐ OVEN TEMPERATURE:

300

FINISH TIME:

8:45

2 Bl 10-7-13.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60308

Thursday, July 01, 2010 1:11:51 PM



Page 2

Item ID: D2261

Accept



Setup Start



Revision ID:

Stop



Item Name: Mirror Arm - Long S76

Start Date: 7/1/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
		=> 30		10.107113		X2	0		
140 Small Fab Small Fab Small Fab	Small Fab Memo Assemble as per dwg D2261	0.00 0.00							
		= 7 M.L		10/07/14		(2x)	0		
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
		S 10/07/15				(2)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60308

Thursday, July 01, 2010 1:11:51 PM



Page 3

Item ID: D2261

Accept



Setup Start



Revision ID:

Stop



Item Name: Mirror Arm - Long S76

Start Date: 7/1/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 258

0.00



Packaging

Memo

0.00

Packaging

10/7/15 (2)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-7-15
MF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 01, 2010 1:11:56 PM

Page 1 / 1

Work Order ID: 60308

Parent Item: D2261

Parent Item Name: Mirror Arm - Long S76




Start Date: 7/1/2010

Required Date: 7/8/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP : D02.04.15 Added dwg Rev.A1 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
A1449  Grommet		Purchased	No			100	Each	1,194.000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST281				1194					
					1487			1194					
D2022-101  Spacer		Manufactured	No			140	Each	155.0000	4	1487 8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				155					
				50746				55					
				52325				100					
M304TR0.500W.035  304 RD Tube .500 x .035W		Purchased	No			140	f	125.1920	2.9791	6.271789			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT				105.227137					
					114482 ✓			105.227137					
				MAT014				19.96082					
					114356			19.96082					
				MAT017				0.004					
					112800			0.004					

1487
8

50746 6x
52325 2x

6.271789

M. L

W/07/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

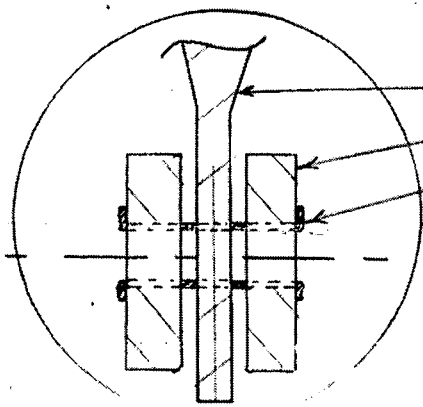
NOTE: Date & initial all entries



DRAWN M. Cohen.	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN	DRAWING NO. D2261	REV. A SHEET 1 OF 1
Aug 10/94	TITLE LONG TUBE	
A1 CP 0203.22 ADD FINISH		

Should be D2022-101

SPACER CP 0301.06



D2261 LONG TUBE
D2012-101 SPACER (2x)
A1449 GROMMET

ASSEMBLE PER DETAIL
AND SWAGE GROMMET
(2 LOCATIONS)

STANDARD FLARE
BOTH ENDS
(PARALLEL TO PLANE
OF BENDING)

MATL: 304SS 1/2" OD x .035" WALL TUBE

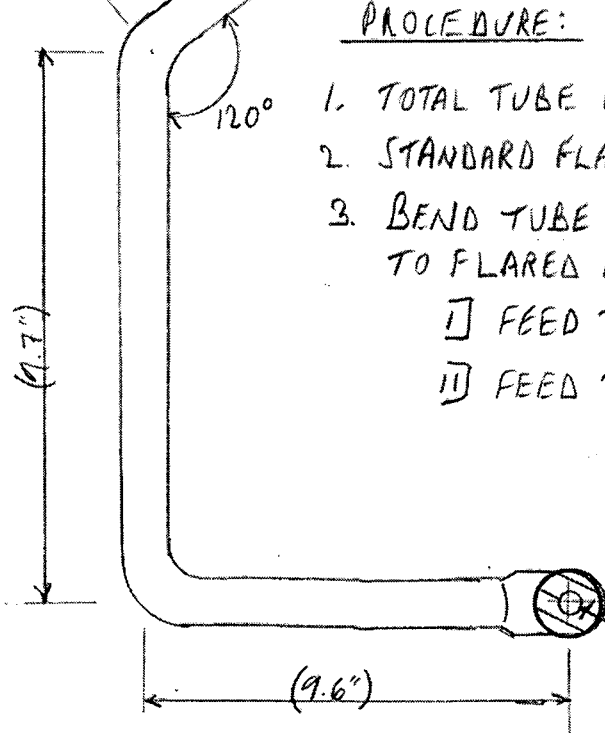
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART 051 005 4.3 A1

PROCEDURE:

1. TOTAL TUBE LENGTH = 35.75"
2. STANDARD FLARE BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.

I] FEED THRU 11", BEND 90°

II] FEED THRU 19 3/4" (TOTAL), BEND 60°



2.57" Dia Both Ends

SUBJECT: UNCON
WORK:
NO. 60308

2/10-201

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries